

Date: Wednesday, 7/11/2007 2:49:41 PM
 User: Kim Johnston

Process Sheet

| | | | |
|-----------------------|---------------------------------------|------------------|-----------------|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : SADDLE BILLET |
| Job Number | : 33496 | | |
| Estimate Number | : 10033 | | |
| P.O. Number | : <i>NA</i> | Part Number | : D6101003 |
| This Issue | : 7/11/2007 S.O. No. : <i>NA</i> | Drawing Number | : D6101 REV A |
| Prsht Rev. | : NC | Project Number | : N/A |
| First Issue | : <i>NA</i> Type : MACHINED PARTS | Drawing Revision | : A |
| Previous Run | : 31387 | Material | : <i>NA</i> |
| Written By | : _____ | Due Date | : 7/31/2007 |
| Checked & Approved By | : <i>7/07/11</i> | Qty: | 20 Um: Each |
| Comment | : Est. A: 01.05.04 New Issue EC | | |

Additional Product

Job Number:



| | | |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

| | | |
|-----|----|------------|
| 1.0 | PG | PURCHASING |
|-----|----|------------|



Comment: PURCHASING

Issue P/O: *4152**C 207/07/12*

a) Description: Alluminum billet

b) 7.875" x 6.250" x 2.00" thick

c) Tolerance on all dimensions are +0.030"/-0.000"

d) Grain direction along 7.875" length

e) Material: 7075-T7351 (QQ-A-250/12)

f) Material certification required

(20)

| | | |
|-----|-----------|-------------------------|
| 2.0 | D6101003P | 7075-T7351 2X6.25X7.875 |
|-----|-----------|-------------------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)

7075-T7351 2X6.25X7.875

| | | |
|-----|-------------|-----------------------|
| 3.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
|-----|-------------|-----------------------|



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure material certification is attached

C 207/07/26 (20)

| | | |
|-----|-----|-------------------|
| 4.0 | QC6 | DIMENSIONAL CHECK |
|-----|-----|-------------------|



Comment: DIMENSIONAL CHECK

Ensure Material certification comply to Dwg D6101

BG 07.07.26 24

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/07/07
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Wednesday, 7/11/2007 2:49:41 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE BILLET

Job Number: 33496

Part Number: D6101003

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Haas

U *CP 07/07/26* *(21)*

6.0

QC21

FINAL INSPECTION/W/O RELEASE



(21)

Comment: FINAL INSPECTION/W/O RELEASE

U *07/07/27*

Job Completion



U *07/07/27*

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

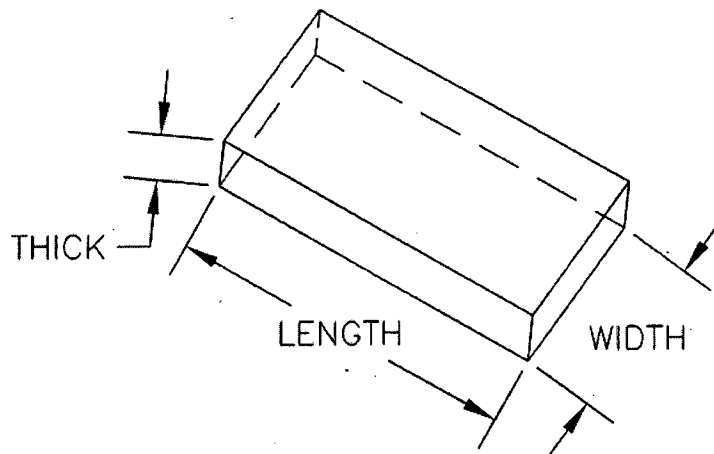
NOTE: Date & initial all entries



| | | | |
|---------------------|-----------------------|---|------------------------|
| DESIGN <i>CP</i> | DRAWN BY <i>CP</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>#</i> | APPROVED <i>JS</i> | DRAWING NO. D6101 | Rev. A SHEET 1 OF 1 |
| DATE 01.03.30 | | TITLE SADDLE BILLET, 7075 | SCALE NTS |
| A | 01.03.30 | NEW ISSUE | |

SPECIFICATION CONTROL DRAWING

RELEASED
01.04.23 *CP*



PURCHASE MATERIAL ACCORDING TO THE FOLLOWING TABLE. SPECIFY ALLOY, LENGTH x WIDTH x THICK (+0.030/-0.000), AND GRAIN DIRECTION AS SHOWN.

TOLERANCES ON ALL DIMENSIONS ARE +0.030/-0.000.

ALL DIMENSIONS ARE IN INCHES.

| Part No. | Alloy | Length | Width | Thick | Grain Direction |
|-----------|--------------------------|--------|-------|-------|--------------------|
| D6101-001 | 7075-T7351 (QQ-A-250/12) | 6.000 | 6.250 | 2.000 | Along 6.000 Length |
| D6101-003 | 7075-T7351 (QQ-A-250/12) | 7.875 | 6.250 | 2.000 | Along 7.875 Length |
| D6101-005 | 7075-T7351 (QQ-A-250/12) | 5.000 | 8.250 | 2.500 | Along 5.000 Length |
| D6101-007 | 7075-T7351 (QQ-A-250/12) | 7.750 | 8.250 | 2.500 | Along 7.750 Length |
| D6101-009 | 7075-T7351 (QQ-A-250/12) | 8.700 | 8.250 | 2.500 | Along 8.700 Length |
| D6101-011 | 7075-T7351 (QQ-A-250/12) | 9.700 | 8.250 | 2.500 | Along 9.700 Length |
| D6101-013 | 7075-T7351 (QQ-A-250/12) | 10.100 | 8.250 | 2.500 | Along 10.10 Length |
| | | | | | |
| | | | | | |
| | | | | | |
| | | | | | |
| | | | | | |

SHOP COPY
RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. **33496**

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SHIP TO:

TRANSTAR METALS
4175 ROYAL DRIVE SUITE 600
KENNESAW, GA 30144

KAISER ALUMINUM

Trentwood Works - Spokane, WA 99215
Phone: (800) 367-2586

P.O.#
84652

SOLD TO:

TRANSTAR METALS INC.
ATTN: ACCOUNTS PAYABLE DEPT.
970 W. 190TH STREET
SUITE 700
TORRANCE, CA 90502

CERTIFIED TEST REPORT

Serial Number
4094045

| | | | | |
|---------------------------------|-------------------------|--|------------------------------|---|
| CUSTOMER PO NUMBER: 00138510 | WORK PACKAGE: | CUSTOMER PART NUMBER: 152000X48.57L | SHIP RINLOAD ID: 100951/2 | GOVT CONTRACT NUMBER: |
| KAISER ORDER NO: 1047898 | LINE ITEM: 1 | SHIP DATE: 12-APR-2007 | ALLOY: 7075 | CLAD: BARE |
| WEIGHT SHIPPED: 7244 LB | QUANTITY: 5 PCS EST. | S/L NUMBER: 2012428 | TEMPER: T7351 | PRODUCT DESCRIPTION: MILL FINISH PLATE |
| | | GAUGE: 2.0000 IN | WIDTH: 48.500 IN | LENGTH: 144.500 IN |

Certified Specifications

AMS 4078/RevF
ASTM B 209/Rev06
B88 7055/RevA
DP8 4.713/RevN/AmdAF
GSS18100/RevG

AMS-QQ-A-250/12
ASTM B 594/Rev06
CMMP 025/RevQ
EAC M91011/RevD
MMS 159/RevN

AMS-STD-2184
BAC 5439/RevH
CSTI 008/RevQ
QAMPS 9101/RevB
PS 21211/RevK

Test Code: 4287

Test Results

Lot: 993118A9 Cast 885

Drop 51

Ingot 1

| | | | | | |
|----------|--------|------------------|----------------------------|----------------------------|--------------|
| Tensile: | Temper | Dir / # Tests | Ultimate KSI (MPA) | Yield KSI (MPA) | Elongation % |
| | T7351 | LT / 2 (Min:Max) | 73.1 : 73.8 (504 : 507) | 62.9 : 63.8 (434 : 436) | 10.7 : 11.1 |

| | | |
|----------------------|----------|----------|
| Conductivity %IACS : | 41.1 Min | 41.2 Max |
| (MS/M) : | 23.6 Min | 23.9 Max |

| | | | | | | | | | | | |
|------------|------|------|------|------|------|------|------|------|------|------|----------|
| Chemistry: | SI | FE | CU | MN | MG | CR | ZN | TI | V | ZR | OTHER |
| Actual | 0.10 | 0.21 | 1.52 | 0.03 | 2.43 | 0.20 | 6.79 | 0.03 | 0.01 | 0.02 | TOT 0.02 |

CASTLE METALS CORP.
DATE RCVD 5/7/07
IAC 6857
APPROVED BY fw-2pgs

RECEIVED
APR 16 2007

**KAISER
ALUMINUM**Trentwood Works - Spokane, WA 99215
Phone: (800) 367-2586**CERTIFIED TEST REPORT**Serial Number
4094045

Lot: 388468A9 Cast 985

Drop 24

Ingot 4

| | | | | | |
|----------------------|--------|------------------|----------------------------|----------------------------|--------------|
| Tensile: | Temper | Dir / # Tests | Ultimate KSI (MPA) | Yield KSI (MPA) | Elongation % |
| | T7351 | LT / 2 (Min:Max) | 72.9 : 73.0 (508 : 509) | 82.1 : 82.4 (428 : 430) | 11.4 : 12.0 |
| Conductivity %IACS : | | | 41.9 Min | 41.8 Max | |
| (MS/M) : | | | 24.0 Min | 24.1 Max | |

| | | | | | | | | | | | |
|------------|------|------|------|------|------|------|------|------|------|------|----------|
| Chemistry: | SI | FE | CU | MN | MG | CR | ZN | TI | V | ZR | OTHER |
| Actual | 0.08 | 0.19 | 1.48 | 0.02 | 2.45 | 0.21 | 5.87 | 0.03 | 0.01 | 0.01 | TOT 0.03 |

ALLOY LIMITS

| | | | | | | | | | | | | |
|------------|------|------|------|------|------|------|------|------|------|------|-------|------|
| Chemistry: | SI | FE | CU | MN | MG | CR | ZN | TI | V | ZR | OTHER | MAX |
| 7075 MIN | 0.00 | 0.00 | 1.20 | 0.00 | 2.10 | 0.18 | 5.10 | 0.00 | 0.00 | 0.00 | EACH | 0.05 |
| MAX | 0.40 | 0.50 | 2.00 | 0.30 | 2.90 | 0.28 | 6.10 | 0.20 | 0.05 | 0.05 | TOT | 0.15 |

Aluminum Remainder**TEST NOTES**

Metal represented by this test report was immersion ultrasonically tested from one side and meets the Class A and Class B requirements of all specifications referenced on this test report.

CERTIFICATION

KAISER ALUMINUM & CHEMICAL CORPORATION (KAISER) HEREBY CERTIFIES THAT METAL SHIPPED UNDER THIS ORDER WAS MELTED AND MANUFACTURED IN THE U.S.A. AND HAS BEEN INSPECTED, TESTED, AND POLISHED IN CONFORMANCE WITH THE REQUIREMENTS OF THE APPLICABLE SPECIFICATIONS AS INDICATED HEREIN. ALL METAL WHICH IS SOLUTION HEAT-TREATED COMPLIES WITH ALL U.S. MIL-SPEC. ANY WARRANTY IS LIMITED TO THAT SHOWN ON KAISER'S STANDARD GENERAL TERMS AND CONDITIONS OF SALE. TEST REPORTS ARE ON FILE, SUBJECT TO EXAMINATION. TEST REPORTS SHALL NOT BE REPRODUCED EXCEPT IN FULL, WITHOUT THE WRITTEN APPROVAL OF KAISER ALUMINUM & CHEMICAL CORPORATION LABORATORY. THE SIGNATURE OF KAISER, NOTIFICATION, OR FRAUDULENT STATEMENTS OR ENTICES ON THE CERTIFICATE MAY BE PUNISHED AS A FELONY UNDER FEDERAL LAW. ISO-9001:2000 CERTIFIED

BILL POYNOR, LABORATORIES SUPERVISOR


Page 2 of 2



| | | | | | | | | | | | |
|---|--|---|--|--|--|---|--|-------------------------------------|--|----------------------------------|--|
| 1 334347 70/42/ 24 | | REQUISITION CLIENT-CUSTOMER REQUISITION NO. | | NO. COM. CLIENT-CUST. ORD. NO. 4152 | | COMPT-ACCT. VEND. SLS TERR. EXPEDIE PAR-SHIP VIA 91037 200 40 TRUCK (PPD) MA210001 | | BILL | | NO. FEVILLE/EMBALLAGE-B/L NUMBER | |
| ETEUR-PURCHASING AGENT INDA LACELLE | | TELEPHONE 613 632-3336 | | H/C TAXE NO. COM ORD 9 0 1 | | REGION LIVRAISON-DEL ZONE C/C | | PREPAID | | | |
| IE A-SHIP TO: | | VENDU A-SOLD TO: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY | | ON K6A 1K7 | | INFORMATION CRÉDIT-CREDIT INFORMATION | | ROUTE 01-NL-07/23 31-NL-07/24 | | | |
| INSTRUCTIONS/LIVRAISON-DELIVERY INQ-E55600 | | INSTRUCTIONS LIVRAISON (CONT.)-DELIVERY (CONT'D.) | | | | INSTRUCTIONS LIVRAISON (CONT.)-DELIVERY (CONT'D.) | | | | | |

| | | | | | | | |
|--|--|---|--|---|--|--------------------------------|--|
| DESCRIPTION - ITEM 1 2.0000 PLATE 7075-T7351 ALUM 6.25" X 7.875" BLACK W/RED STRIPE | | QTE/UNITE COM. ORDERED 20 PCS | | PCES/PO COM. ORD. PCS | | POIDS COM. -WT. ORDERED 199 | |
| | | BALLOTS-BUNDLES 1 | | PCES/PO EXP. SHP. 21 | | POIDS EXP.-WT. SHIPPED 199 | |
| A.M. Castle & Co. certifies that the material(s) supplied under this document will meet and conform to the specifications of the product(s) described hereon. A.M. Castle & Co. (Canada) Inc. | | INSTRUCTIONS TOL: +.025" / -.000" THICKNESS TOL.: +.030" / -.000" GRAIN TO RUN ALONG 7.875" PRIOR DIST/ORD: 01 967427 | | COULÉE INFO-HEAT INFO QTE-QTY 393118AS | | FORME-SHAPE I.A.C. 6057 | |
| WEIGHT FOR SHIPPING PURPOSES ONLY. SEE INVOICES FOR ACCURATE BILLING WEIGHT. PLEASE SIGN AND DATE DRIVER'S COPY FOR RECEIPT OF MATERIAL AND, IF CHECKED, TEST REPORTS. | | INSTRUCTIONS (CONT'D.) 2.14 6 1/4" x 7.875" | | | | ENT-WI N6 | |

| | | | | | | | |
|---|--|------------------------|--|-------------------------------|--|-------------------------|--|
| DESCRIPTION - ITEM 2 | | QTE/UNITE COM. ORDERED | | PCES/PO COM. ORD. | | POIDS COM. -WT. ORDERED | |
| | | BALLOTS-BUNDLES | | PCES/PO EXP. SHP. | | POIDS EXP.-WT. SHIPPED | |
| TERMS AND CONDITIONS OF SALE SEE DISCLAIMERS AND LIMITATIONS ON THE REVERSE SIDE | | INSTRUCTIONS 1 Box | | COULÉE INFO-HEAT INFO QTE-QTY | | FORME-SHAPE I.A.C. | |
| | | INSTRUCTIONS (CONT'D.) | | | | ENT-WI | |

| | | | | | | | |
|---|--|-------------------------|--|-------------------------------|--|-----------------------------------|--|
| DESCRIPTION - ITEM 3 | | QTE/UNITE COM. ORDERED | | PCES/PO COM. ORD. | | POIDS COM. -WT. ORDERED | |
| | | BALLOTS-BUNDLES | | PCES/PO EXP. SHP. | | POIDS EXP.-WT. SHIPPED | |
| ALL EXCEPTIONS FOR SHORTAGE OR DAMAGE MUST BE NOTED ON THE DRIVER COPY & CUSTOMER COPY OF THE DELIVERY RECEIPTS & SIGNED BY THE DRIVER & CUSTOMER. COPY OF SUCH RECEIPT PROPERLY NOTED MUST BE SUBMITTED WITHIN 10 DAYS WHEN CREDIT IS REQUESTED. | | INSTRUCTIONS | | COULÉE INFO-HEAT INFO QTE-QTY | | FORME-SHAPE I.A.C. | |
| NOM (LETTRE MOULÉE)-NAME (PRINT ONLY) | | INSTRUCTIONS (CONT'D.) | | | | ENT-WI | |
| RECU PAR-RECEIVED BY | | DATE RECU-DATE RECEIVED | | | | FEVILLE D'EMBALLAGE - PACKING SLI | |